

Work Order ID 60587

Page 1

Thursday, July 15, 2010 10:18:11 AM

Item ID: D205-708-011

Accept



Setup Start



Revision ID:

Item Name: Adjustable Engine Mount

Stop



Start Date: 7/15/2010 Start Qty: 2.00



Cust Item ID:

Required Date: 7/22/2010 Req'd Qty: 2.00



Customer:

Reference:

Approvals: Process Plan:



Date: 10-7-15 Tooling:

Date:

Run Start



QC:

Date: SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

B80701

Rev C

100



DOCUMENT CONTROL

DC

Document Control

Memo

0.00

Photocopy bluefile and create labels per PPP D205-708-011, CHG001

110



PURCHASING

Purchasing

Memo

0.00

Purchasing

Issue P/O: 12260 for:

6 ✓	D3284-001 ✓	(B80702-1)	Sleeve
2 ✓	D3284-003 ✓	(B80703-1)	Stud
4 ✓	D3284-005 ✓	(B80704-1)	Stud
6 ✓	D3284-007 ✓	(B80705-1)	Stud
6 ✓	NAS509-12 ✓	Nut	
6 ✓	NAS509L12 ✓	NutStud	

To be assembled as per Dwg B80701 Rev. C
 Possible Supplier: Northern Aero
 Certificate of Conformity is required

88 10/09/15 | 31

H for BG 10-9-01

②

CL 10/17/15 ②

②

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 60587

Thursday, July 15, 2010 10:18:11 AM



Page 2

Item ID: D205-708-011

Accept



Setup Start

**Revision ID:****Item Name:** Adjustable Engine Mount

Stop

**Start Date:** 7/15/2010 **Start Qty:** 2.00**Cust Item ID:****Required Date:** 7/22/2010 **Req'd Qty:** 2.00**Customer:****Reference:****Approvals:****Process Plan:****Date:** _____**Tooling:** _____**Date:** _____

Run Start

**QC:** _____**Date:** _____**SPC (Y/N):** _____**Date:** _____

Stop

**Sequence ID/
Work Center ID****Operation
Description****Set Up/
Run Hours****Tool ID****Tool #****Plan
Code****Accept
Qty****Reject
Qty****Reject
Number****Insp.
Stamp**

120



Packaging

Receive & Inspect for Damage & Mat'l Certs

0.00

14/11/3

Packaging

Memo

0.00

Receive & Inspect For Transit Damage Ensure Certificate of Conformity is attached

130



QC

QC5- Inspect part completeness to step on W/O

0.00

5/10/11/31

Quality Control

Memo

0.00

Inspect assembly. Visually inspect thread, fit and cad plating

12

135



Packaging

Pick Kit

0.00

10/9/11/31

Packaging

Memo

0.00

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 60587

Thursday, July 15, 2010 10:18:11 AM



Page 3

Item ID: D205-708-011

Accept



Setup

Start



Revision ID:

Item Name: Adjustable Engine Mount

Stop



Start Date: 7/15/2010 Start Qty: 2.00



Cust Item ID:

Required Date: 7/22/2010 Req'd Qty: 2.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run

Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

140



QC

Quality Control

QC4- 100% Inspect kits for completeness

0.00

8/10/10

0.00

(X2)

150



Packaging

Packaging

0.00

Memo

0.00

Identify and pack for shipping as per PPP D205-708-011

Location: 5

PPP Rev: 4

8/10/10 (2)

160



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

10/09/14 (1)
MF
10-9-14

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Thursday, July 15, 2010 10:18:16 AM

Page 1

Work Order ID: 60587



Parent Item: D205-708-011



Parent Item Name: Adjustable Engine Mount

Start Date: 7/15/2010

Required Date: 7/22/2010

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP C 06.01.31 Added MS206136C12 JLM/AP
IPP Rev:D 07-12-12 as per ECN 1074 DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3284-001 		Manufactured	No			140	Each	2.0000	6	12		B60587	
Sleeve							<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>				
					ST049			2					
					59910			2					
D3284-003 		Manufactured	No			140	Each	6.0000	2	4		B60587	
Stud							<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>				
					ST049			6					
					32724			4					
					35656			2					
D3284-005 		Manufactured	No			140	Each	6.0000	4	8		B60587	
Stud							<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>				
					ST049			6					
					39942			2					
					43645			4					

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Thursday, July 15, 2010 10:18:16 AM

Page 2

Work Order ID: 60587



Parent Item: D205-708-011



Parent Item Name: Adjustable Engine Mount

Start Date: 7/15/2010

Required Date: 7/22/2010

Start Qty: 2.00

Required Qty: 2.00

D3284-007



Manufactured No

140

Each

13.0000

6

12

B60587 (80705) C

Stud

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
-----------------	----------------	-----------------

ST	6	
59048	6	
ST049	7	
55427	1	
59048	6	

D3284-009



Manufactured No

140

Each

2.0000

6

*12 1 B61236 107/25f
B61802 20 107/25f C*

Bearing

D3284-011



Manufactured No

140

Each

18.0000

1

2 107/25f

Bearing

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
-----------------	----------------	-----------------

ST046	17	
60004	17	
ST50	1	
58724	1	

MS20613-6C12



Purchased No

140

Each

105.0000

2

4 107/25f (2)

RIVET

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
-----------------	----------------	-----------------

ST322	105	
100089	6	
105433	99	

V

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Thursday, July 15, 2010 10:18:16 AM

Page 3

Work Order ID: 60587



Parent Item: D205-708-011



Parent Item Name: Adjustable Engine Mount

Start Date: 7/15/2010

Required Date: 7/22/2010

Start Qty: 2.00

Required Qty: 2.00

MS20613-6C16

Purchased

No

140

Each

26.0000

8

16



10/9/12 SP

S
Rivet

MS20613-6C18

Purchased

No

140

Each

47.0000

4

10

8
10/9/12 SP

S
Rivet

Use 6C20 Batch M112511

MS20613-6C19

Purchased

No

19513

Location

Loc Qty

Loc Code

ST323

26

26



8

24
M112941 SP

S
Rivet

NAS509-12

Purchased

No

140

Each

0.0000

12



12
B60587 SP

Nut

NAS509L12

Purchased

No

140

Each

40.0000

6



12
B60587 SP

Nut

Location

Loc Qty

Loc Code

ST280

36

15057

36

Location

Loc Qty

Loc Code

ST280

40

102296

31

15062

9

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

SPECIFICATION CONTROL DRAWING

DART P/N	SPECIFICATION
D3284-001 SLEEVE	ACS P/N B80702-1 PER ACS DWG B80702 REV. A
D3284-003 STUD	ACS P/N B80703-1 PER ACS DWG B80703 REV. A
D3284-005 STUD	ACS P/N B80704-1 PER ACS DWG B80704 REV. A
D3284-007 STUD	ACS P/N B80705-1 PER ACS DWG B80705 REV. B
D3284-009 BEARING	BHT P/N 47-140-252-5
D3284-011 BEARING	BHT P/N 205-060-101-001
D3284-021 TUBE ASSY	204-060-158-001 MODIFIED PER IIN-D205-708
D3284-023 BIPOD ASSY	204-060-155-001 MODIFIED PER IIN-D205-708
D3284-025 TRIPOD ASSY	204-060-157-001 MODIFIED PER IIN-D205-708
D3284-031 TUBE ASSY	205-060-107-001 MODIFIED PER IIN-D205-708
D3284-033 BIPOD ASSY	205-060-106-001 MODIFIED PER IIN-D205-708
D3284-035 TRIPOD ASSY	205-060-105-001 MODIFIED PER IIN-D205-708



NOTE:

FOR FUTURE PROCUREMENT, THE PURCHASE ORDER MUST SPECIFY THAT THE MATERIAL USED TO MANUFACTURE THE D3284-001/003/005/007 PARTS MUST COMPLY WITH THE FOLLOWING SPECIFICATIONS:

AISI 4130 ROUND BAR PER AMS 6348/MIL-S-6758 WITH
 MIN Ftu = 90 ksi
 MIN Fty = 70 ksi

EACH INDIVIDUAL ITEM TESTED BEFORE USE OR PROVEN TO EQUAL OR EXCEED THE ABOVE.

CL101715
 W10.60587

B	ADD NOTE	RF	09.07.14
A	NEW ISSUE	KJ	04.05.06
REV.	DESCRIPTION	BY	DATE
DESIGN	DS	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>[Signature]</i>	D3284	SHEET 1 OF 1
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	ADJUSTABLE ENGINE MOUNT	NTS
DATE	09.07.14	COPYRIGHT © 2004 BY DART AEROSPACE LTD <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

RELEASED
 2010-03-25
[Handwritten signature]

S-NAI**INVOICE**

5
Avenue
Reg. MB R2X 2V2
Tel: 204-772-9922
Fax: 204-772-7568

CUSTOMER NO. 1030019
INVOICE 12142
INVOICE DATE 30-08-2010

BILL TO:
Dart Aerospace Ltd.
1270 Aberdeen Street

SHIP TO:
Dart Aerospace Ltd.
1270 Aberdeen Street

Hawkesbury, ON K6A 1K7
Canada

Hawkesbury, ON K6A 1K7
Canada

Attention: Accounts Payable

SHIP DATE	SHIP VIA	TERMS			
10-08-2010	FEDEX ACCT# 2351 4353 4	Net 30 Days			
P.O. NUMBER	ORDER DATE	OUR ORDER NUMBER			
10: PO12260	27-08-2010	23228			
DESCRIPTION	S/N	SHIP QTY.	UNIT UOM	EXT. PRICE	PRICE
3. EEEVE	10-3000	12	EA	117.00	1,404.00
3 STUD	08-2515	4	EA	84.00	336.00
4 STUD	08-1927	3	EA	84.00	672.00
10	10-2599	12	EA	96.00	1,152.00
1/4 (.7500-16 UNJF-3B)	07-2750	12	EA	11.54	138.48
1/4 STEEL (.7500-16 UNJF-3B-LH) LH THREAD	08-1060	12	EA	11.54	138.48

CURRENCY

SHIP VIA: FEDEX ACCT# 151793240

ORDERED BY: CHANTAL LAVOIE @ 613-632-9577

8/20/08/31

Net Amount: 3,840.96

H.S.T. (ONT) 13% 499.32

G.S.T. # 89515 7576 RT0001

USD Total Due\$ 4,340.28



25 Dunlop Ave
Winnipeg, Manitoba, Canada, R2X 2V2
Ph: 204-772-9922 Fax: 204-772-7568

CERTIFICATE OF CONFORMITY

Form Tracking No.23228-1		Work Order/Contract/Invoice PO 12260	Cage Code: MFR L0555		
Item 1 2 3 4	Description Sleeve Stud Stud Stud	Part No. B80702-1 B80703-1 B80704-1 B80705-1	Quantity 12 4 8 12	Serial/Batch 10-3000 08-2515 08-1927 10-2599	Status manufactured manufactured manufactured manufactured

508831

Remarks:

THESE ITEMS CONFORM TO APPROVED DESIGN DATA B80702 (REV. A), B80703-1 (REV. A), B80704-1 (REV. A)
AND B80705-1 (REV. B), AS APPLICABLE.

New-Unused Parts/Material Certification		Used, Repaired or Overhauled Parts Certification	
The items described above have been manufactured using standards employed by a TCCA approved manufacturer in accordance with CAR 561 and a AS9100 Quality Assurance System.		The items described above have been maintained using standards employed by a TCCA approved maintenance organization in accordance with CAR 573 and a AS9100 Quality Assurance System.	
Signature		Signature	
Name R. D. WILLIAMSON	Date (dd mmm yyyy) 27 AUG 10	Name	Date (dd mmm yyyy)
User/Installer Responsibilities: This certificate does not constitute authority to install the item(s) described above on an in-service type certified aircraft.			

ACS-NAI Ltd.
 25 Dunlop Avenue
 R2X 2V2 Winnipeg
 Canada
 Tel : 204-772-9922
 Fax : 204-772-7568

Delivery No. : 1194
 Delivery Date : 08/27/2010
 SO No. : 23228
 Your Reference : PO: PO12260
 Delivery Method : FEDEX ACCT# 2351 4353 4
 Payment Condition : Net 30 Days

Delivery to: Dart Aerospace Ltd.

Attention: Chantal Lavoie
 1270 Aberdeen Street

Hawkesbury K6A 1K7
 Canada

Item	Description	Batch Number	Total Ordered	Unit	Qty Delivered	Delivery Date
B80702-1	SLEEVE 10-3000		✓ 12	EA	12	08/30/2010
B80703-1	7/8 STUD 08-2515		✓ 4	EA	4	08/30/2010
B80704-1	3/4 STUD 08-1927		✓ 8	EA	8	08/30/2010
B80705-1 10/08/31	STUD 10-2599		✓ 12	EA	12	08/30/2010
NAS509-12	NUT (.7500-16 UNJF-3B) 07-2750		✓ 12	EA	12	08/30/2010
NAS509-L12	NUT STEEL (.7500-16 UNJF-3B-LH) LH THREAD 08-1060		✓ 12	EA	12	08/30/2010

US CURRENCY
 SHIP VIA: FEDEX ACCT# 151793240
 ORDERED BY: CHANTAL LAVOIE @ 613-632-9577

10/08/31

Packages: 0

Gross Weight: 0.00

Net Weight:

Ordered by: Dart Aerospace Ltd.

Attention: Chantal Lavoie
 1270 Aberdeen Street
 Hawkesbury K6A 1K7
 Canada

Invoice to: Dart Aerospace Ltd.

0.00

Attention: Accounts
 1270 Aberdeen Street
 Hawkesbury K6A 1K7
 Canada

Remarks:

Certification Statement

I hereby certify that the aircraft part(s) described hereon were acquired from a source of supply that is consistent with the conditions under which TCCA distributor approval AMO88-97 has been granted.

[Signature]
 Signatory

27 Aug 2010
 Date: